

Date: Friday, 9/21/2007 1:03:41 PM
User: Kim Johnston

Process Sheet

41

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34798
Estimate Number : 10262
P.O. Number : *N/A*
This Issue : 9/21/2007 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : LANDING GEAR
Previous Run : 33960
Drawing Name : 350 SKIDTUBE ASSEMBLY LH
Part Number : D350636011
Drawing Number : D2750 REV E
Project Number : N/A
Drawing Revision : E
Material : *N/A*
Due Date : 10/13/2007 Qty: 1 Um: Each
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est Rev.I 02-09-25 Rearranged procedure steps KJ
Est Rev.J 06-03-23 As per Rev D JLM
Est Rev.K 06-07-13 As per dsi9343 EC
Est Rev.L 07-07-28 Added SS Wearplates(Rev E) JLM
Verified By: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 07.09.26

Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 003

ED 07/11/10

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

32448

7-10-3

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch

32584

7-10-10

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end.

2- Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8863 drilling holes labelled "A" only.

K 7-10-3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 34798

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description:

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for Detail B using DT8330

5-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297" ***Make sure that wearplate holes are on bottom of tube*****

7-Open up holes of Detail A to 0.250" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004 Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *m 105138 BE 7-10-10*

10-Grind welds flush as per Dwg D2750 *SL 7-10-11*

12- Scribe batch# inside per dwg D2750

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION *PD 07-10-15*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP *SL 7-10-15*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *JB 7-10-15*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION *BE 7-10-16*

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch: *29985*

SL 7-10-17

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 34798

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: B33824 BE 07/10/18

11.0

D34903

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: B33825 BE 07/10/18

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch: B32656 BE 07/10/18

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail D to 0.750" (total of 4 holes per side)
as per dwg D2750.

3-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on
sheet 4)

4-Deburr and blow out all chips from inside of tube

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch: 105586

exp. date: 8-7-1

7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 4)

A/R

Aluminum Rod

batch: m105058

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 07/11/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				
07/10/18	#17	while drilling out webs in cross bolt spacer #17 from aft the drill went side ways and scored the side of the D3490 cross bolt spacer	<u>QSA12</u>	Drill out cross bolt spacer #17 from aft.	BE 07/10/18	<u>07/10/18</u>	<u>QSA12</u>	<u>07/10/18</u>
		R.C. Hammer error		Re install / weld a new D3490 3 B# 1 33825	BE 07/10/18	<u>07/10/18</u>	<u>QSA12</u>	<u>07/10/18</u>
				As per Q52004		<u>07/10/18</u>	<u>QSA12</u>	<u>07/10/18</u>
				Re grind and polish	H 7-10-18	<u>07/10/18</u>	<u>QSA12</u>	<u>07/10/18</u>

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 34798

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

10-Deburr holes

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-23 (1)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EC 07/10/23

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

M 105008

BR 07-10-24

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

MS

07-10-26

Q

18.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Insert

Batch:

B 100621

BR

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

BR

07-11-01

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

EC

07/10/29

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing

Batch:

B 32990

MS

07-11-01

Q

W/O:		WORK ORDER CHANGES						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 34798

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D353513

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B 34316

JS

23.0

D353525

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B 34317

JS

24.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B 33371

JS

25.0

D353613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 32742

JS

26.0

D353625

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 32741

JS

27.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 33659

JS

28.0

D35371

WEARPAD



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

WEARPAD

Batch: B 34282

JS

07-11-01

Q

W/O:		WORK ORDER CHANGES						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 34798

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D36311

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: B34276

JS

30.0

D3488041

BLADE FITTING ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B32232

JS

31.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B33075

JS

32.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B32997

JS

33.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: * B105426(x36) + M106112(x2)

JS

34.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M105052

JS

35.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M103668

JS

07-11-01 0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 34798

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M104937

JL

37.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M102671

JL

38.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: M105900

JL

39.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M105408

JL

40.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M103693

JL

41.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M104628

JL

42.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M105116

JL

07-11-01

U

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 34798

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M105430

JL

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: M105005

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M105585

EXP DATE: 08-07

4-Coat all exposed fasteners with "LPS Procyon" batch: M104251

D 10-11-01

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 7/11/01

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

47.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 333083

SP

48.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M104605

7/11/01 SD

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 34798

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description:

49.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: *M106043*

SP

50.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: *M104958*

SP

51.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: *M104625*

SP

52.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: *132085 34820*

SP

53.0

D35321

spacer



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)

batch:

132085

7/10/07

SP (N)

54.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5/11/07

55.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

REV F 6/14/07 (1)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 34798

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

56.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/07/11/02

Job Completion



12/07/11/02

334798

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART**RELEASED**
07.08.02

DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED HA	DRAWING NO. D2750	REV. E SHEET 1 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157	
E	07.05.17	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

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NO. **34798**

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 2 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

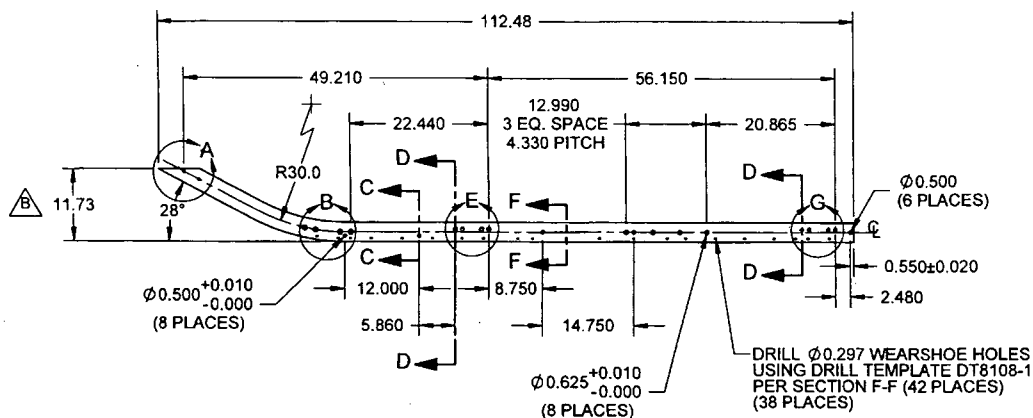
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1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ($\emptyset 0.297$) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS POWDER COATING WITH MEK DEGREASER.

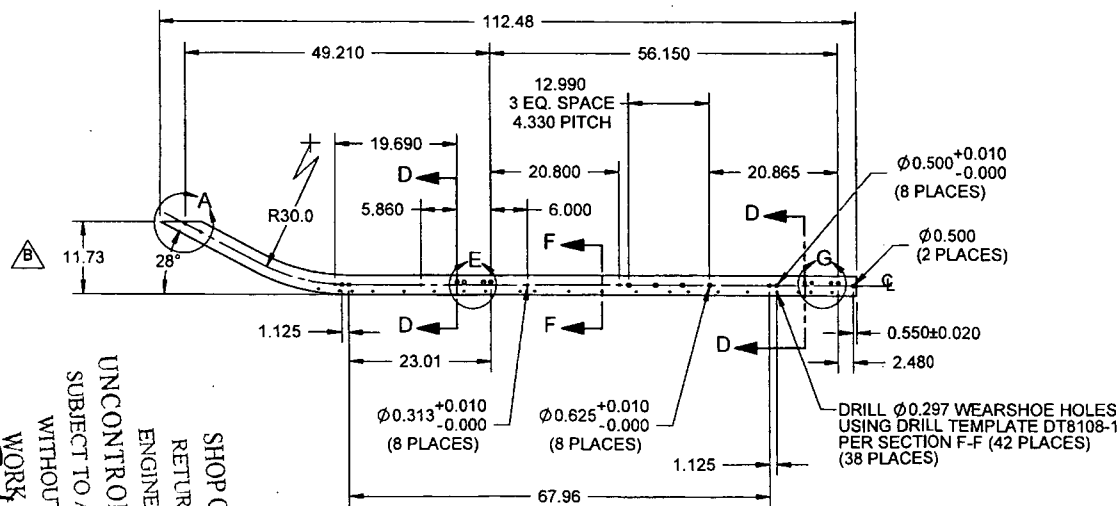
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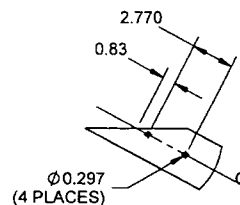
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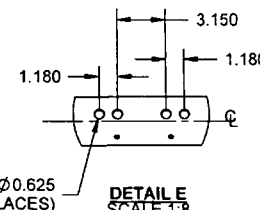
D2750-1 LH SKIDTUBE (SHOWN)
D2750-2 RH SKIDTUBE (OPPOSITE)



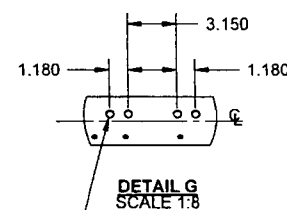
D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)



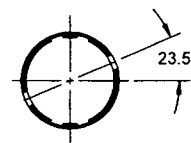
DETAIL A
SCALE 1:8



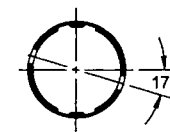
DETAIL E
SCALE 1:8



DETAIL G
SCALE 1:8

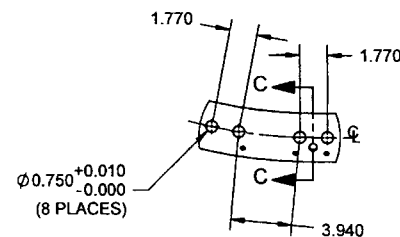


SECTION C-C
SCALE 1:4

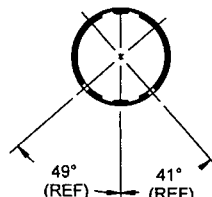


SECTION D-D
SCALE 1:4

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DETAIL B
SCALE 1:8
(ALL DIMENSIONS ARE STRAIGHT LINE DIMENSIONS)



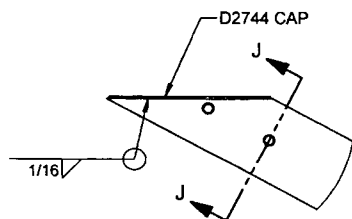
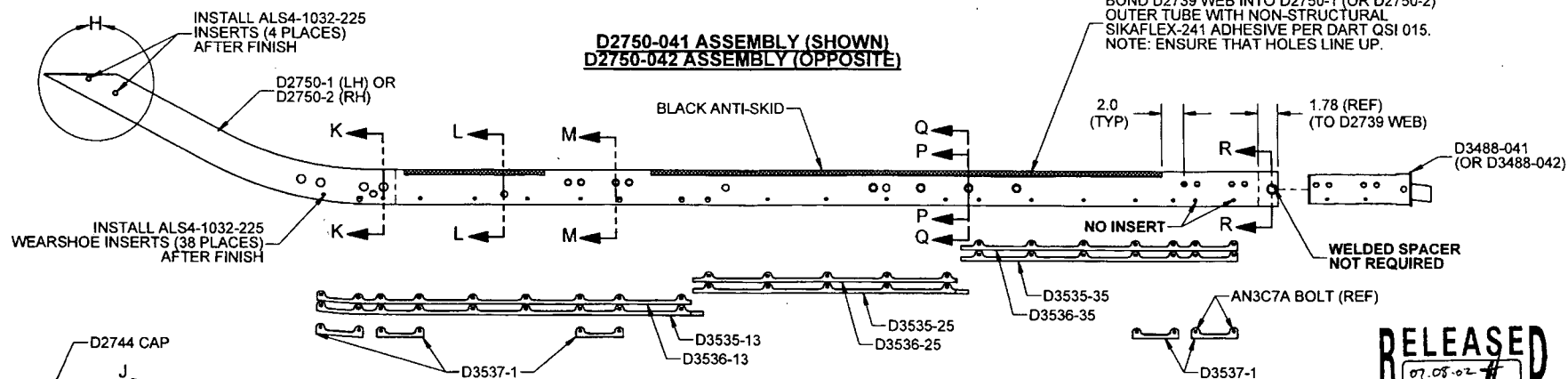
SECTION F-F
SCALE 1:4

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DATE 07.05.17	TITLE 350 SKIDTUBE ASSEMBLY		SCALE 1:20

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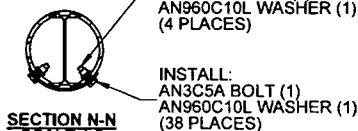
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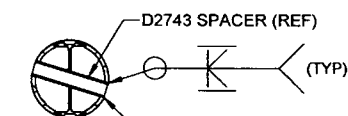
DETAIL H
SCALE 1:5



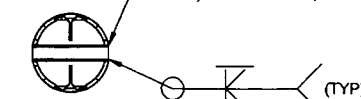
SECTION J-J
SCALE 1:5



SECTION N-N
SCALE 1:5



SECTION M-M
SCALE 1:5



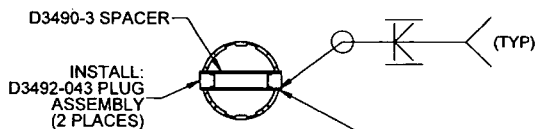
SECTION P-P
SCALE 1:5



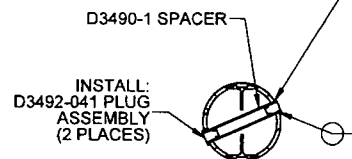
SECTION Q-Q
SCALE 1:5



SECTION R-R
SCALE 1:5



SECTION K-K
(FOR $\phi 0.750$ HOLES ONLY)
SCALE 1:5



SECTION L-L
(FOR $\phi 0.500$ HOLES ONLY)
SCALE 1:5

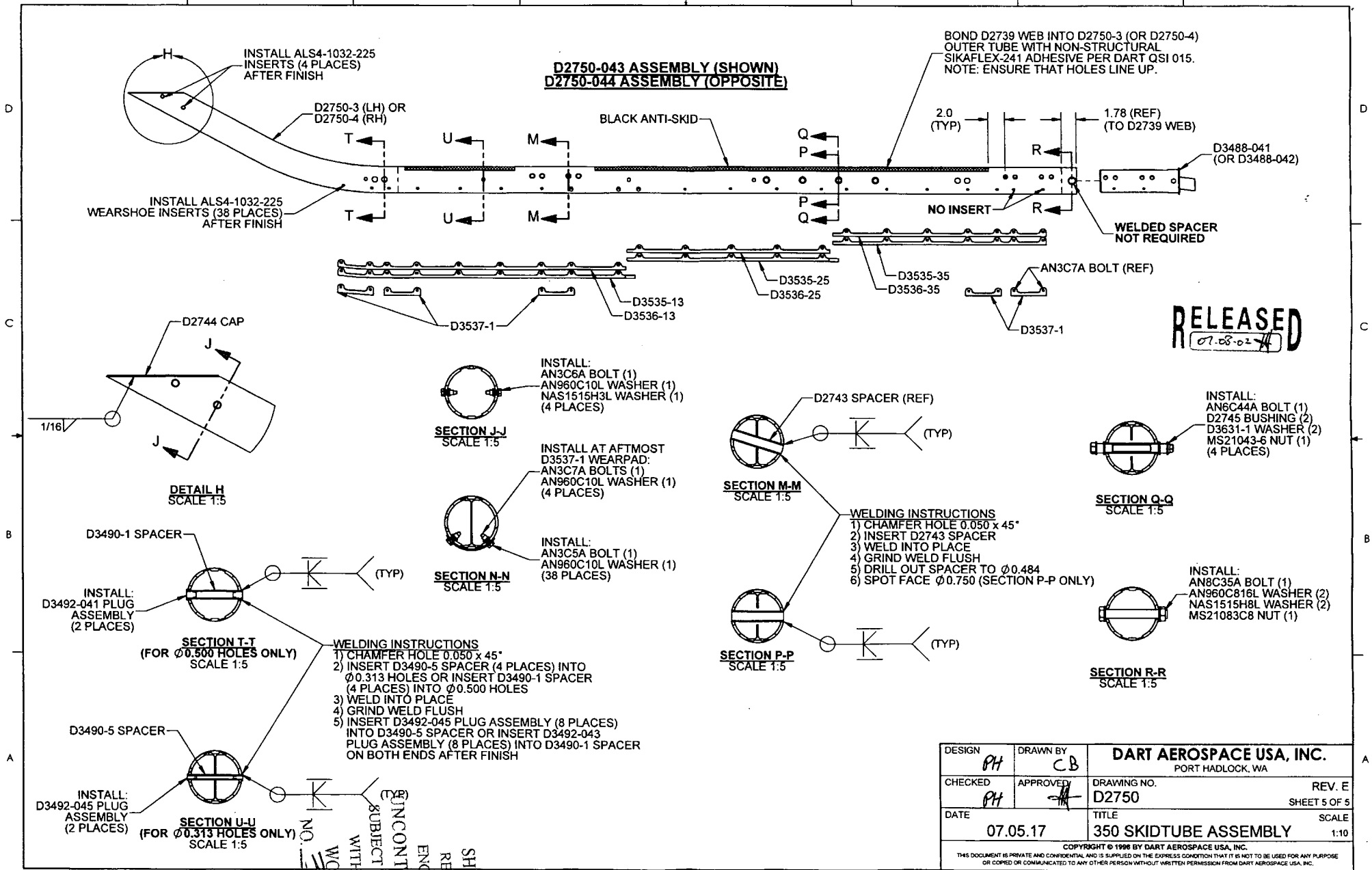
- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE $0.050 \times 45^\circ$
 - 2) INSERT D3490-1 SPACER (4 PLACES) INTO $\phi 0.500$ HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO $\phi 0.750$ HOLES
 - 3) WELD INTO PLACE
 - 4) GRIND WELD FLUSH
 - 5) INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS AFTER FINISH

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE $0.050 \times 45^\circ$
 - 2) INSERT D2743 SPACER
 - 3) WELD INTO PLACE
 - 4) GRIND WELD FLUSH
 - 5) DRILL OUT SPACER TO $\phi 0.484$
 - 6) SPOT FACE $\phi 0.750$ (SECTION P-P ONLY)


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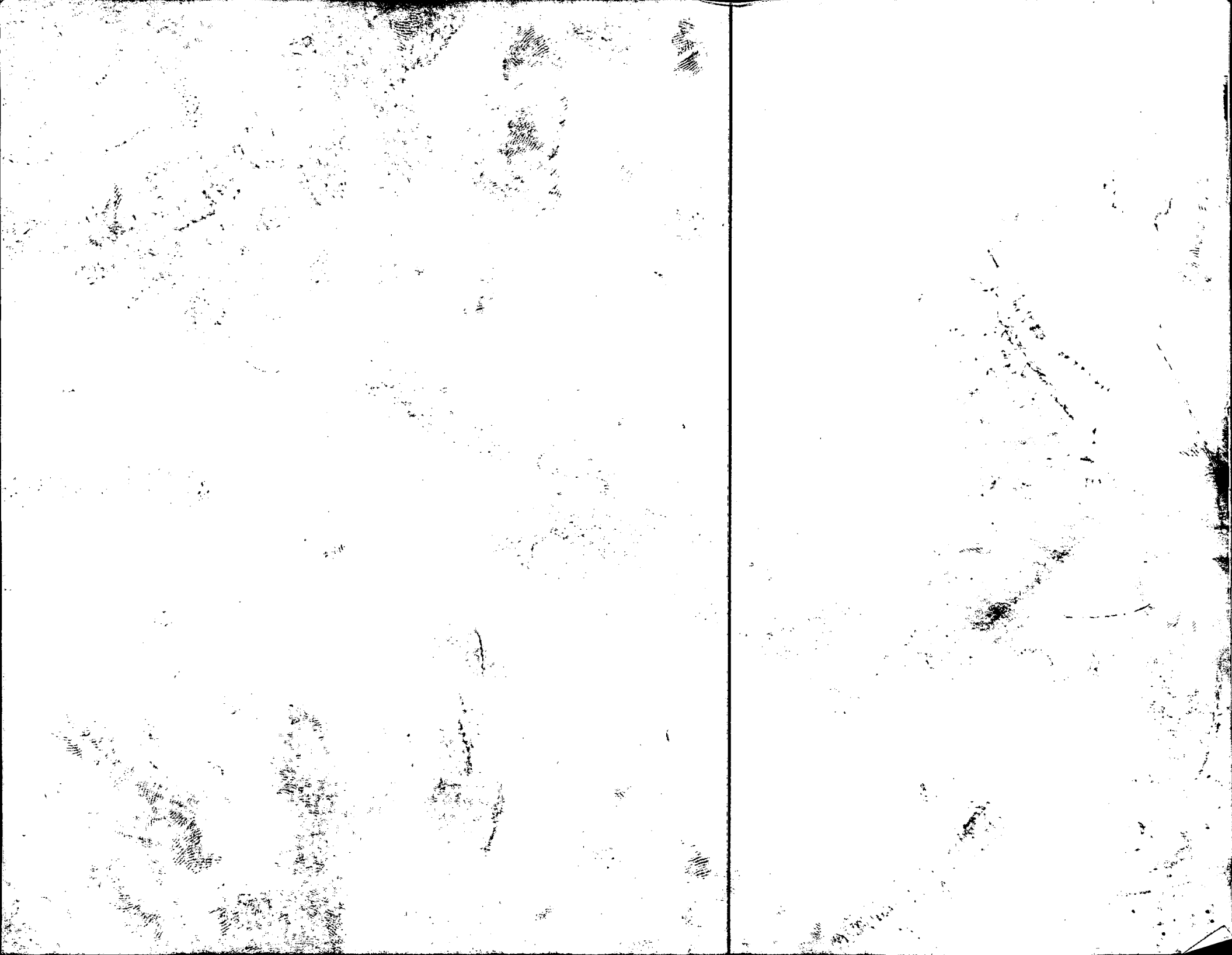
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PH	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. E
PH	[Signature]	D2750	SHEET 4 OF 5
DATE		TITLE	SCALE
07.05.17		350 SKIDTUBE ASSEMBLY	1:10
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8 7 6 5 4 3 2 1



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DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:10
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NO. 130

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name Darley Elliot
Joint Welding Procedure E1
Part number and Job number 0550 6000 / 033961

TEST WELDS REQUIRED

BASE METAL Aluminum WELDING PROCESS E1
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>			
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>	
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>	
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>	
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>	
Crossbolt Spacer Welded into <u>Skidtube</u>					

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 01-10-09 Qualifier Pat Del